इंटरनेट मानक

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IS 6001 (1971): Flyer Spindles [TXD 14: Machinery for Fabric Manufacture]

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“Knowledge is such a treasure which cannot be stolen”

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UDC 677·052·24 ( Second Reprint AUGUST 1991 ) IS : 6001 - 1971

(Reaffirmed 2012)

*Indian Standard*

# SPECIFICATION FOR FLYER SPINDLES

**1. Scope** — Prescribes the requirements of flyer spindles for use in conjunction with speed frames having lifts from 200 to 350 mm.

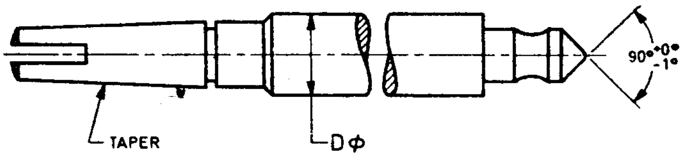
## 2. Manufacture

**2.1** *Material* — High-carbon steel chosen from IS : 1570-1961 'Schedules for wrought steels for general engineering purposes' so as to achieve the degree of hardness as specified in **3.2**.

**2.2** *Workmanship and Finish* — Spindles shall be free from scars, cracks, traces of rust, burrs or any other surface defect. The spindles shall have a perfect smooth ground finish with roughness not exceeding 0·4 µm Ra.

## 3. Requirements

**3.1** *Shape and Dimensions*



| *Lift* | *DΦ* |
|---|---|
| mm | mm |
| 200 | 22 |
| 250 | 22 |
| 300 | 22 |
| 300 | 25 |
| 350 | 25 |

**Note** — Lift of flyer spindles is not generally determined on the basis of any of the spindle measurements but refers to the maximum distance travelled by the bobbin rail in the speed frame during formation of layers of rove on the bobbins.

FIG. 1 FLYER SPINDLE

**3.1.1** Tolerances on the various dimensions shall be as under:

| *Dimension* | *Tolerance* |
|---|---|
| | mm |
| Overall length | ± 0·8 |
| Body diameter | + 0·00<br>− 0·05 |

**3.2** *Hardness* — The hardness at tip of the spindle, as measured on Rockwell C scale according to the method prescribed in IS : 1586-1968 'Method for rockwell hardness test (B and C scales) for steel (*first revision*)', shall be 58 *HRC, Min*.

**3.3** *Trueness* — The true running at any portion of the spindle shall be within 0·05 mm.

**3.3.1** The trueness shall be determined by placing the spindle on V-blocks provided with dial indicators. The readings for outage shall be taken by rotating the spindle.

Spinning Machinery ( Cotton System ) Sectional Committee, TDC 30; Panel for Flyer Spindles, TDC 30/P4 [ Ref: Doc: TDC 30 ( 999 ) ]

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**4. Packing** — Each spindle shall be coated with anti-rust-proofing agent and wrapped in waxed paper. Suitable number of such spindles shall be packed in a wooden case lined with moisture-proof packing paper.

**5. Marking** — Each container of spindles shall be marked with the following:

a) Name of the item;

b) Number of spindles packed;

c) Length and diameter of spindles; and

d) Manufacturer's name, initials or trade-mark, if any.

**5.1** *Certification Marking* — Details available with the Bureau of Indian Standards.

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